

What we claim is:

1. A label for a beverage container, comprising:
 - an elongated strip of flexible material having first and second ends, inner
 - 5 and outer surfaces and upper and lower edges;
 - a first quantity of adhesive applied to said inner surface of said strip adjacent to said first end;
 - a second quantity of adhesive applied to said inner surface of said strip adjacent to said second end;
 - 10 a third quantity of adhesive applied to said inner surface of said strip in a region spaced from said first and second ends;
 - a tear line extending laterally across said strip between said upper and lower edges, said tear line being positioned adjacent to said third quantity of adhesive between said third quantity of adhesive and said second end of the strip,
 - 15 and defining an adhesive-free area on said inner surface between said tear line and said second quantity of adhesive; and
 - said material of said strip comprising a tamper-evident structure.
2. The label of claim 1, wherein said tamper-evident structure comprises a
- 20 frangible material that leaves a residue of fibers when peeled from a quantity of adhesive.
3. The label of claim 1, wherein said material of said strip has a core layer and at least one bonding layer.
- 25 4. The label of claim 3, wherein said material of said strip comprises a core layer positioned between a pair of bonding layers.
5. The label of claim 1, wherein said second quantity of adhesive is applied
- 30 to said label in a pattern of three elongated stripes, one stripe being parallel and adjacent to said second end and the other stripes being parallel to said upper and

lower edges with one of said other stripes being adjacent to said upper edge and the other being adjacent to said lower edge.

6. The label of claim 1, wherein said second quantity of adhesive is applied
5 to said label in the form of discrete dots covering an area of said inner surface.

7. The label of claim 1, wherein said second quantity of adhesive is applied
to said label in the form of a pair of rectangles spaced apart from each other
adjacent to said second end of the label.

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8. The label of claim 1, wherein said first and third quantities of adhesive are
applied to said label as continuous layers forming elongated stripes extending
from said upper to said lower edges.

15 9. The label of claim 8, wherein said stripe containing said first quantity of
adhesive has a width narrower than a width of said stripe containing said third
quantity of adhesive.

10. The label of claim 1, wherein said material of said strip comprises oriented
20 polypropylene comprising a cavitated core and a printable skin layer on at least
one side of the core.

11. The label of claim 1, wherein said adhesive-free area supports printed
information.

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12. The label of claim 1, wherein said adhesive-free area forms a flat, flexible
gaming device.

13. The label of claim 1, wherein a part of said label between said tear line and
30 said second end is in the form of a detachable printed voucher having printing on
said inner surface.

14. The label of claim 13, wherein a part of said label between said tear line and said first end is in the form of a product label having printed information on said outer surface.
- 5 15. The label of claim 1, wherein said second quantity of adhesive is smaller in one or more of applied area, amount and bonding strength than at least said third quantity of adhesive.
16. A labelled container comprising a container wall adapted to enclose a
10 product and a label according to claim 1 encircling said container wall.
17. The labelled container of claim 16, wherein said container is a soft drink bottle.
- 15 18. The labelled container of claim 16, wherein said first quantity of adhesive adheres said first end of said label to said wall of said container, said third quantity of adhesive adheres said inner surface of the label partly to said outer surface of the label at said first end and partly to said wall of said container, and said second quantity of adhesive adheres said second end of said strip to said outer
20 surface of said strip.
19. The labelled container of claim 18, wherein said label has a strength and said second quantity of adhesive adheres to said outer surface of said label with an adhesive strength adapted to prevent accidental detachment of said strip at said
25 second end during storage and transportation of said labelled container, but to allow deliberate manual peeling of said second end from said outer surface of said strip.
20. A method of producing a label and attaching said label to a container
30 having an outer wall; comprising:
providing an elongated band of pre-printed flexible material comprising a tamper-evident layer;

cutting said band into a plurality of elongated strips each having first and second ends, inner and outer surfaces and upper and lower edges;

for each strip:

advancing said strip longitudinally and creating a transverse tear line

5 extending laterally across said strip between said upper and lower edges, said tear line being positioned intermediate said first and second ends;

applying a first quantity of adhesive to said inner surface of said strip adjacent to said first end, a second quantity of adhesive to said inner surface of said strip adjacent to said second end, and a third quantity of adhesive to said

10 inner surface of said strip in a region spaced from said first and second ends adjacent to said tear line between said tear line and said first quantity of adhesive; and

connecting said first quantity of adhesive to a container, rotating said container to cause said strip to wrap around said container until said third and said
15 second quantities of adhesive adhere to said container or label.

21. The method of claim 20, wherein said container is a soft drink bottle.

22. A method of producing a label and attaching said label to a container
20 having an outer wall; comprising:

providing an elongated band of pre-printed flexible material comprising a tamper-evident layer having a plurality of transverse tear lines at spaced intervals;

cutting said band into a plurality of elongated strips each having first and second ends, inner and outer surfaces, and upper and lower edges, with one of said
25 tear lines extending laterally across each strip between said upper and lower edges between said first and second ends;

for each strip:

advancing said strip longitudinally;

applying a first quantity of adhesive to said inner surface of said strip
30 adjacent to said first end, a second quantity of adhesive to said inner surface of said strip adjacent to said second end, and a third quantity of adhesive to said inner surface of said strip in a region spaced from said first and second ends

adjacent to said tear line between said tear line and said first quantity of adhesive;
and

connecting said first quantity of adhesive to a container, rotating said
container to cause said strip to wrap around said container until said third and said
5 second quantities of adhesive adhere to said container or label.

23. The method of claim 22, wherein said container is a soft drink bottle.

24. Apparatus for producing a label and attaching said label to a container,
10 comprising:

a rotatable support for a continuous elongated band of pre-printed flexible
material;

a cutter adapted to cut said band into a plurality of elongated strips each
having first and second ends, inner and outer surfaces and upper and lower edges;

15 means for advancing said elongated strips;

means for introducing a transverse tear line into each strip as each strip is
advanced, said tear line extending laterally across each strip between said upper
and lower edges, said tear line being positioned intermediate said first and second
ends of each strip;

20 a rotating vacuum drum having a perforated outer surface adapted for
holding and advancing each elongated strip in succession, said drum having raised
projections from said surface at positions corresponding to areas of each strip to
receive a quantity of adhesive;

a source of adhesive;

25 a roller adapted for receiving adhesive on an outer surface thereof and for
application of an adhesive, said roller being positioned adjacent to said vacuum
drum for applying a quantity of adhesive to each strip at positions supported by
said raised projections of said drum,

a conveyor adapted to convey a succession of containers past said vacuum
30 drum at a point where a first end of an elongated strip can be adhered to an outer
wall of said container, said conveyor permitting rotation of said containers by said
drum to enable a strip to be wound around said container and adhered thereto.

25. A vacuum drum for apparatus as defined in claim 24, said drum comprising a perforated outer surface, an inner chamber for development of a vacuum, a plurality of raised projections from said outer surface, and a plurality of
5 vacuum ports communicating with said inner chamber, wherein said projections are raised lands adapted to press an overlying label against a gluing roll arranged at three points around said outer surface in the form of a transverse strip at one position, a transverse strip at a third position and a pair of rectangles at a second position, and wherein said vacuum ports are arranged in a row extending
10 transversely of said outer surface at said second position, with one port located in one of said rectangles and another port arranged in a second of said rectangles.